

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004631**Date Inspected:** 12-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Hu Wei Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

OBG Sub-Assembly Bay 7:

The QA Inspector randomly observed ZPMC welder Hong Shui Li ID 048815, utilizing the Flux Cored Arc Welding (FCAW) Process in the 2G (Horizontal Groove) Position with ZPMC Weld Procedure Specification (WPS) WPS-345-FCAW-2G(2F)-FCM-Repair, to weld the 2 excavations in Weld Joint (WJ) 045 attaching the 30 millimeter (mm) Web Plate to the slotted Flange X7L on Floor Beam Wing Diaphragm FB011-013. The QA Inspector randomly observed ZPMC QC under the supervision of ZPMC CWI Hu Wei Qing, monitoring weld parameters. The weld parameters appeared to comply with contract requirements. The attached photograph provides additional detail.

The QA Inspector randomly observed ZPMC Non-Destructive Testing (NDT) Technician Bo Tin Rui, utilizing the Magnetic Particle testing (MT) Method to perform a final MT Inspection on the cover pass of the welds on Floor Beam Wing Diaphragms FB009-018 (Side A), FB011-012 (Side A) and FB012-012 WJ 045. There appeared to be no indications and ZPMC QC accepted the above listed welds.

The QA Inspector performed a 10% final Visual (VT) and MT verification on the cover pass of all the welds on Floor Beam Wing Diaphragms FB009-018 (Side A), FB011-012 (Side A) and FB012-012 WJ 045. There appeared to be no indications the QA Inspector accepted all of the above listed welds.

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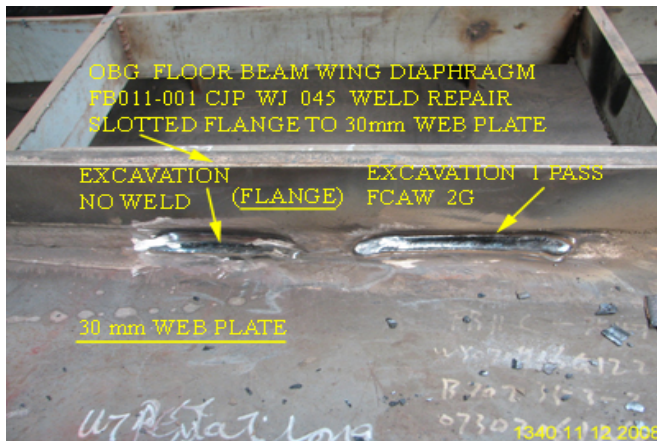
OBG Sub-Assembly Bay 8:

The QA Inspector randomly observed ZPMC Non-Destructive Testing (NDT) Technician Cai Xin Xin, utilizing the MT Method to perform a final MT Inspection on the the outside edge of Web Plate piece mark p244 of 28M Tower Double Diaphragm. The work was being performed in accordance with ZPMC Critical Weld Repair T-CWR029 to add 15 mm to Web Plate p244, to bring the overall length within contract required dimensions. There appeared to be no indications and ZPMC QC accepted the repair.

The QA Inspector randomly observed ZPMC Non-Destructive Testing (NDT) Technician Bo Tin Rui, utilizing the Magnetic Particle testing (MT) Method to perform a final MT Inspection on the cover pass of the welds on Floor Beam Diaphragms FB059-004 (Side A), FB062-001 (Side A), FB003-107 (Side A) and FB003-110 (Side B). There appeared to be no indications and ZPMC QC accepted the welds on the above listed Floor Beam Diaphragms.

The QA Inspector performed a 10% final Visual (VT) and MT verification on the cover pass of all the welds on Floor Beam Diaphragms FB059-004 (Side A), FB062-001 (Side A), FB003-107 (Side A) and FB003-110 (Side B).

There appeared to be no indications and the QA Inspector accepted the welds on the above listed Floor Beam Diaphragms.



Summary of Conversations:

There were no relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Josh Ishibashi 13764716411, who represents the Office of Structural Materials for your project.

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Inspected By: Franco,Charlie

Quality Assurance Inspector

Reviewed By: Wright,Mark

QA Reviewer